

Work Order ID 128592

128592

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Item ID: D2842-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly, 206 Float
 Start Date: 1/19/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1-20-19 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100 0.00
100 Large Fab
 Large Fab
 Large Fab
 Memo 0.00
 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN HOLES***
 3-Deburr and bevel ends for welding

DAS
24
9-89

FEB 25 2015

Dh 15/2/24

110 QC6- Inspect dimensions to drawing 0.00

110 QC
 Quality Control
 Memo 0.00

DAS
24
9-89

FEB 25 2015

2

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 1/19/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				2X		DL 15/2/26	
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00				2		FEB 26 2015	DAS 24 38 9-89 9-89
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: 128956	0.00							
170									
Large Fab	Memo	0.00							
Large Fab	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.					2		FEB 26 2015	DAS 24 38 9-89 9-89

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1 285.92

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 1/19/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 2/06/15 **Req'd Qty:** 2.00 ***?***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 QC10- Inspect visual per QSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

DAS

38

9-89

FEB 26 2015

190 QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS

32

9-90

FEB 26 2015

191 Pressure Wash per QSI005 4.3

0.00

191

HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

2

Cust Item ID:

~

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

0.00

M 124808.

0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE: 275

FINISH TIME: 9:45

0.00

Memo

0.00

OC

Quality Control

0.00

Memo

0.00

HandFinish

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 14130430

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 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 1/19/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
230						②			
QC	Memo	0.00							
Quality Control									15-03-03
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

2 MAR 05 2015

15-03-05

15-3-5

Picklist Print

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Work Order ID: 128592

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 1/19/15

Required Date: 2/06/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

120

Each

111.0000

1

2

D2622-120C

Step Extrusion

DL 15/2/24

Location

Loc Qty

Loc Code

HALL

11

109575

11

WA003

100

125381

100

D2734

Manufactured

No

120

Each

66.0000

2

4

D2734

Step End Plate

FEB 25 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

66

124317

45

125805

21

D3459-1

Manufactured

No

220

Each

24.0000

2

4

D3459-1

Float Step Mounting Plate

FEB 25 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

24

124893

6

125376

6

126297

12

Picklist Print

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Work Order ID: 128592

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 1/19/15

Required Date: 2/06/15

Start Qty: 2.00

Required Qty: 2.00

D3459-3

Manufactured No

120

Each

30.0000

2

4

D3459-3

Float Step Mounting Plate

FEB 25 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

30

124190

6

125129

6

125762

6

126298

12

MS27039C1-07

Purchased

No

220

Each

36.0000

3

6

MS27039C1-07

screw

all 12/03/07

Location

Loc Qty

Loc Code

ST283

36

124580

6

m130566

30

NAS1149C0332R

Purchased

No

100

Each

3,509.000

3

6

NAS1149C0332R

WASHER

all 12/03/07

Location

Loc Qty

Loc Code

FP001

2483

m130325

2483

11131340

GA

26

125654

26

ST271

1000

m130466

1000

Picklist Print

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Work Order ID: 128592

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 1/19/15

Required Date: 2/06/15

Start Qty: 2.00

Required Qty: 2.00

NAS1329C3KB130

Purchased

No

220

Each

41.0000

3

6

NAS1329C3KB130

Insert

ll 5/02/02

Location

Loc Qty

Loc Code

FP001

20

m130281

20

ST267

21

m129207

21

Y6

NAS1515H3L

Purchased

No

220

Each

631.0000

3

6

***NAS1515H3I ***

Washer

ll 5/03/02

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

59

m127831

59

ST266

532

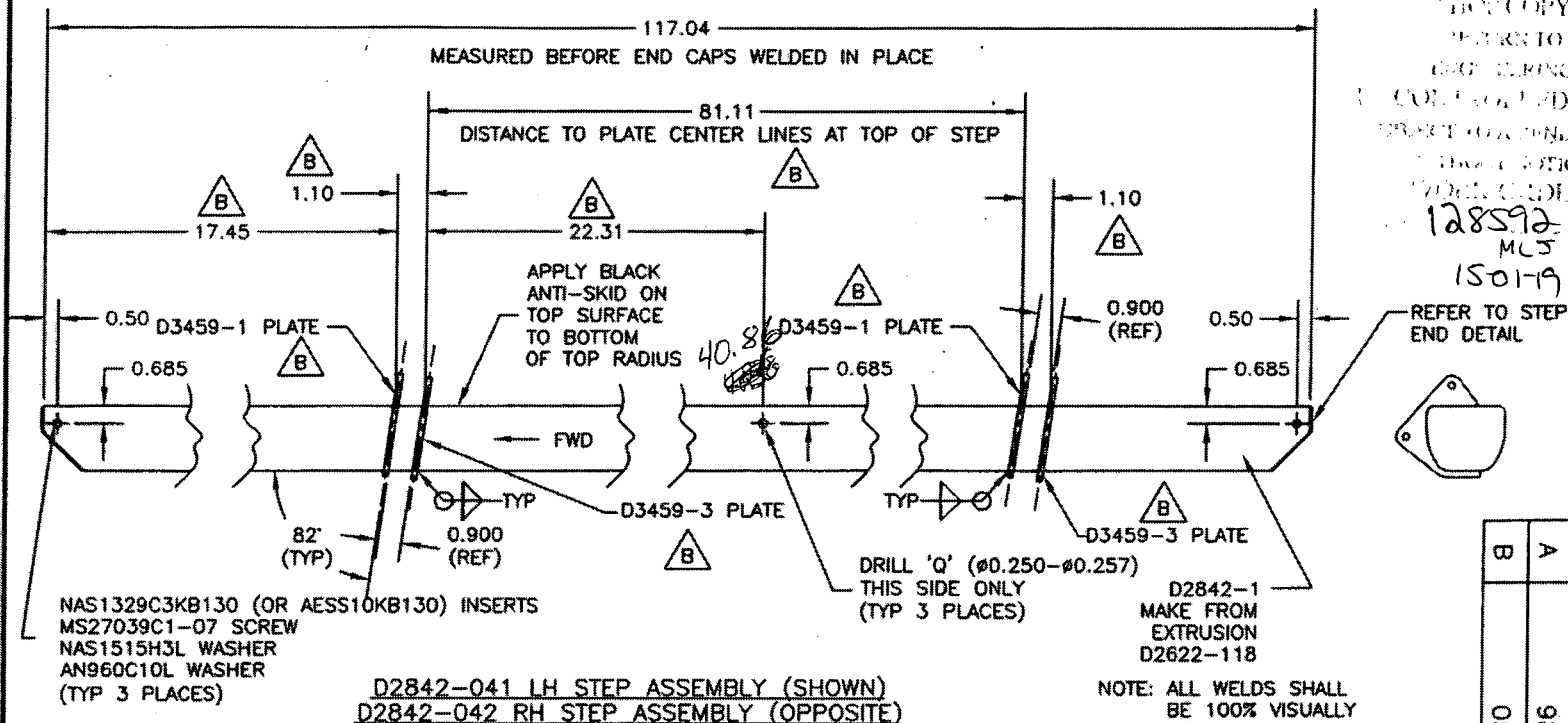
m127831

48

m130726

484

X6



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
X	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS COPY
RETURN TO
DART DURING
PROJECT CLOSURE
128592
MCS
1501-9
REFER TO STEP
END DETAIL



DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
				SHEET 1 OF 1
				SCALE
				2061/407 FLOAT STEP ASSEMBLY
				NEW ISSUE
				RE-DESIGN, ADD D3459-1/-3

RELEASED
05.11.14